

Work Order ID 63449

Tuesday, November 02, 2010 9:21:41 AM

Page 1

Item ID: D4148-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Stud Receiver, Lower

Start Date: 11/2/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/9/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-11-02 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4148

c

100

Cut blanks as per folio

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

5.700" LONG

5.350"

10-11-02

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA944 AND DWG

FOLIO REV: 5

DWG REV: 5

DEBURR

10/11/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Required Date: 11/9/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/09
MF
10-11-9

W/O:		WORK ORDER CHANGES					
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Picklist Print

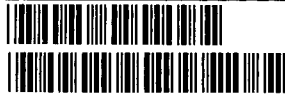
Tuesday, November 02, 2010 9:21:44 AM

Page 1

Work Order ID: 63449

Parent Item: D4148-3

Parent Item Name: Stud Receiver, Lower



Start Date: 11/2/2010

Required Date: 11/9/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X03.000		Purchased	No			100	f	11.5200	0.48	0.96			
303 BAR 1" X 3'													

Location

Loc Qty

Loc Code

MAT

11.52

115555

11.52

1.92 on 10/11/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 63442
Description: <i>Shd Receiver</i>		Part Number: A4148-3
Inspection Dwg: A4148 Rev: C		Page 1 of 1

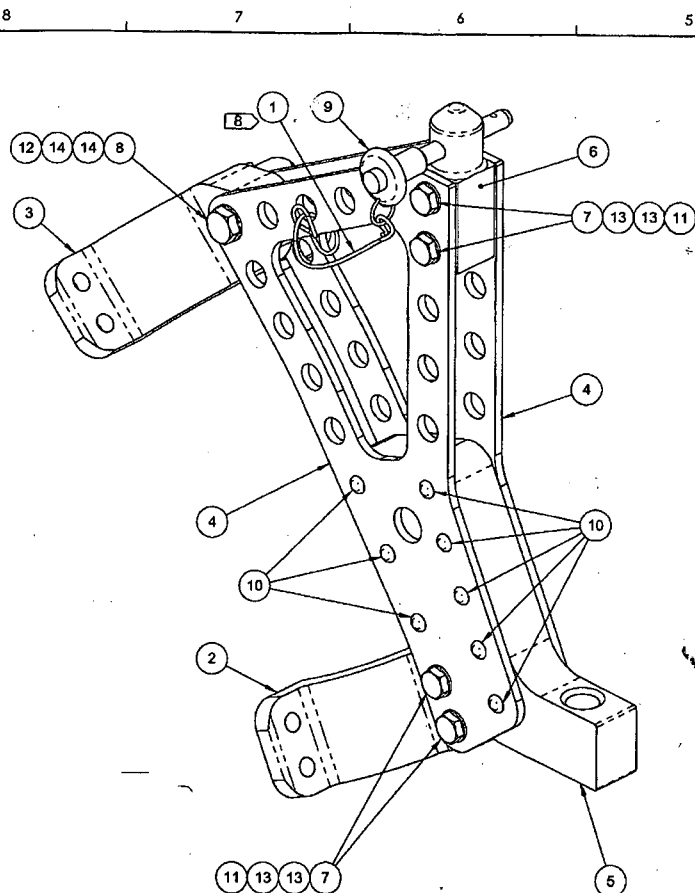
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.50	±.030	Ø.502	/			
1.00	±.030	1.003	/			
.91	±.030	.912	/			
.345	±.010	.3455	/			
1.982	±.010	1.982	/			
3.000	±.010	3.000	/			
1.000	±.020	1.003	/			
3.76	±.030	3.767	/			
.735	+-.000 -0.010	.733	/			
Ø.453	+-.010 -0.000	Ø.454	/			
Ø.250	+-.006 -0.003	Ø.251	/			
.80	±.030	.80	/			
Ø.06 x 45°	±.030	Ø.06 x 45°	/			
.625	±.010	.625	/			
4.65	±.030	4.650	/			

Measured by: <i>SA</i>	Audited by: <i>B.A</i>	Preliminary Approval:
Date: <i>10/11/08</i>	Date: <i>10/11/09</i>	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.63 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	4	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	4	MS21043-3	NUT
12	1	MS21043-4	NUT
13	8	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63449
2810-11-02

RELEASED
2010-10-28

C	REDESIGNED D4148-1A-3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.129 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS Ø.129 (ZN C6-5); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.08.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4148** REV. C
SHEET 1 OF 5

TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

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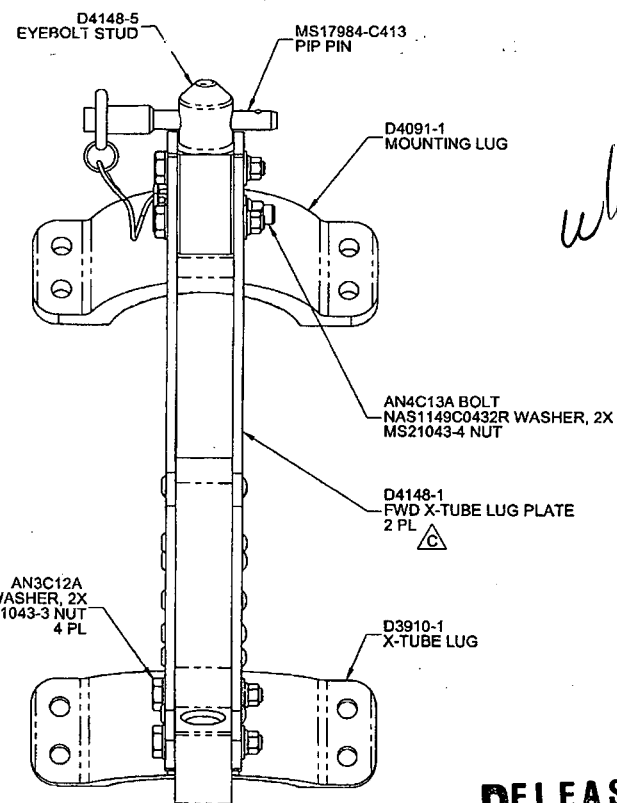
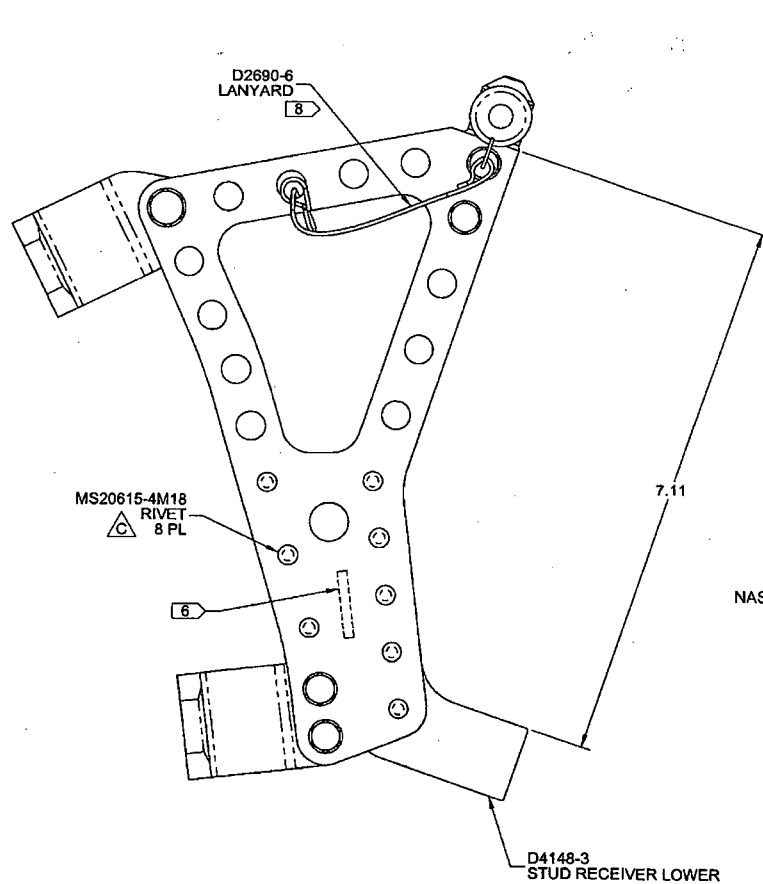
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



RELEASED
2010-10-28

D4148-041 FWD X-TUBE LUG ASSY

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4148	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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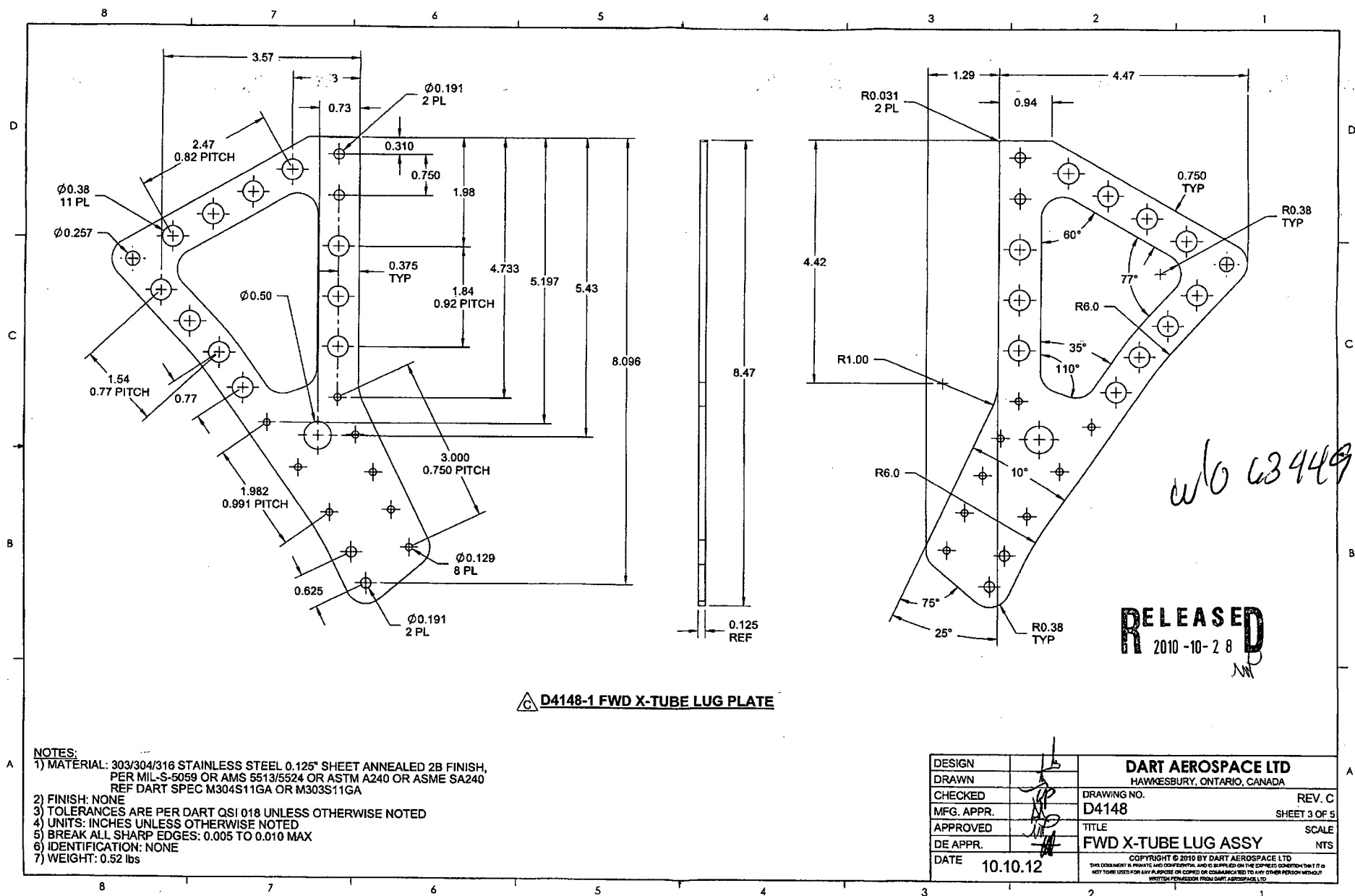
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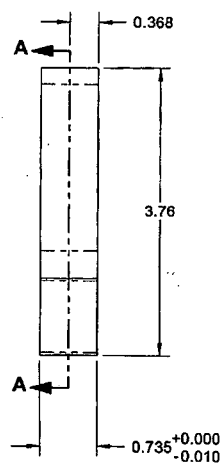
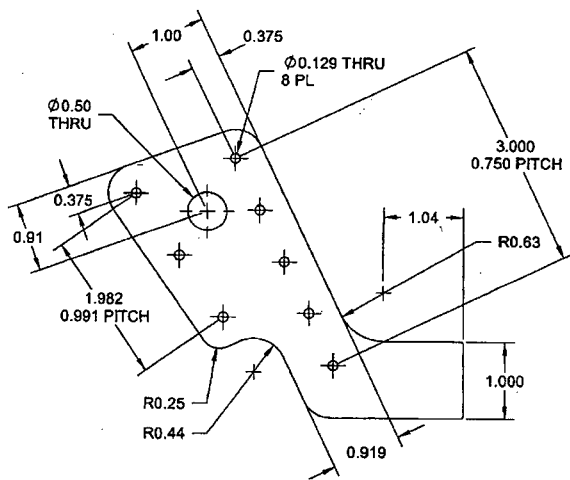
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D

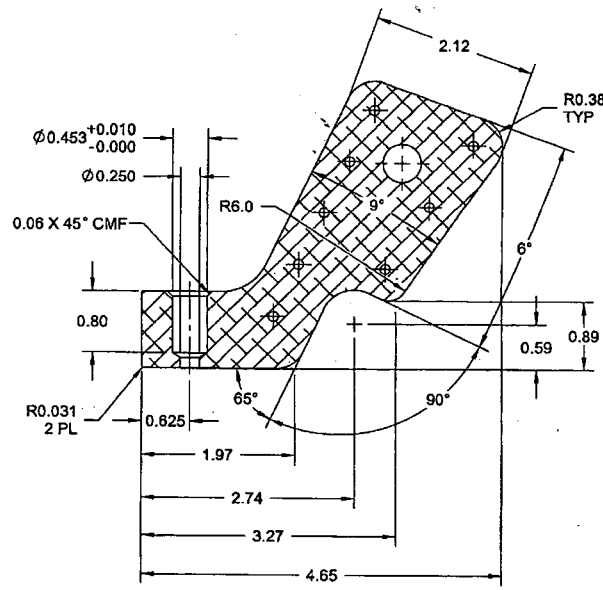
C

B

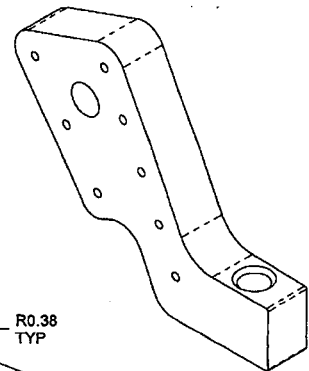
A



D4148-3 STUD RECEIVER LOWER



SECTION A-A



w/b 631149

RELEASED
2010-10-28

- NOTES:**
 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
 REF DART SPEC M304B OR M303B
 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 1.52 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4148	REV. C
MFG. APPR.		TITLE	SHEET 4 OF 5
APPROVED		FWD X-TUBE LUG ASSY	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1

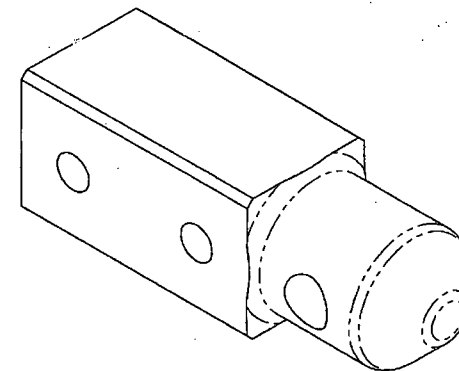
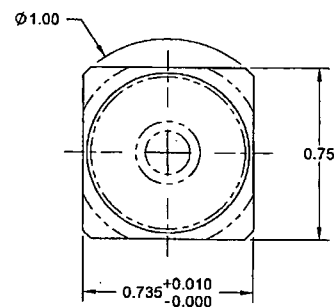
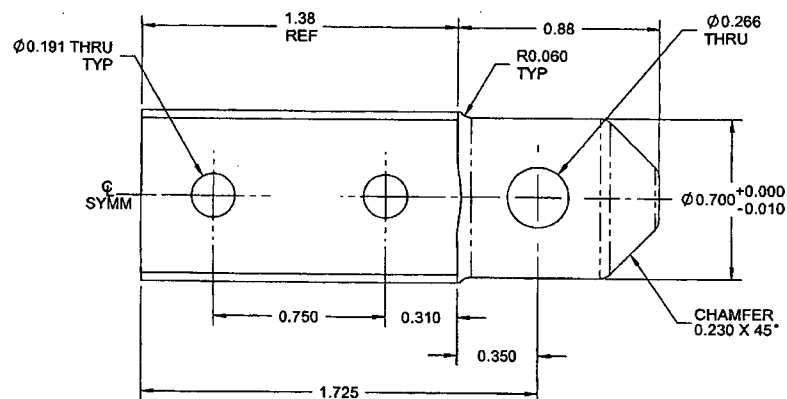
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-5 EYEBOLT STUD

RELEASED
2010-10-28

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4148	REV. C
MFG. APPR.			SHEET 5 OF 5
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